












Date: Thursday, 11/12/2008 10:08:18 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 43992		
Estimate Number	: 10614		
P.O. Number	:	Part Number	: D265621
This Issue	: 11/12/2008 S.O. No. :	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 42776	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08.12.11</u>		
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-11-02 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S20GA	1010/1025 SHEET	
			
Comment: Qty.: 0.9371 sf(s)/Unit Total: 9.3713 sf(s) 1018 20 ga .040" thk Batch: <u>104284</u> <u>HB 8-12-18</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>HB 8-12-18</u> <u>(13)</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>HB 8-12-18</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-12-18</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>S 08/12/18</u> <u>(X/13)</u>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form bend & joggle as per Dwg D2656 using DT8261 & DT8326 <u>CF 08/12/31</u> <u>(13)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:08:18 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43992

Part Number: D265621

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/05 (X13)

7.0

POWDER COATING

POWDER COATING



m109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FZ 09/01/06

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



als



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-01

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

als

09-06-01

(X13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

Job Completion



MF 09-01-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

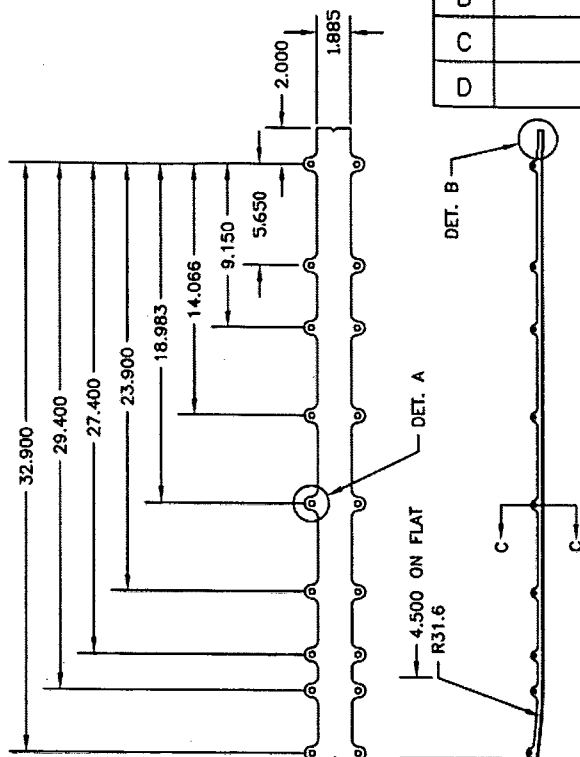
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

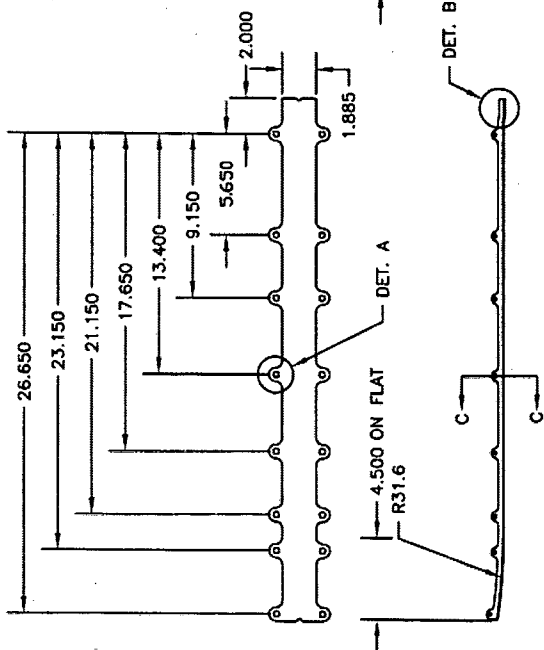


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CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 1 OF 4
				SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

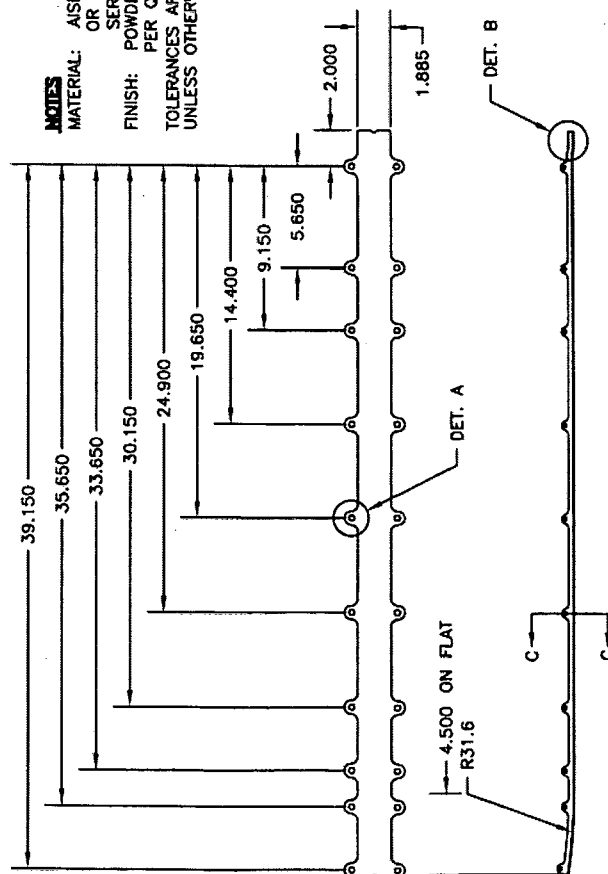
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-08

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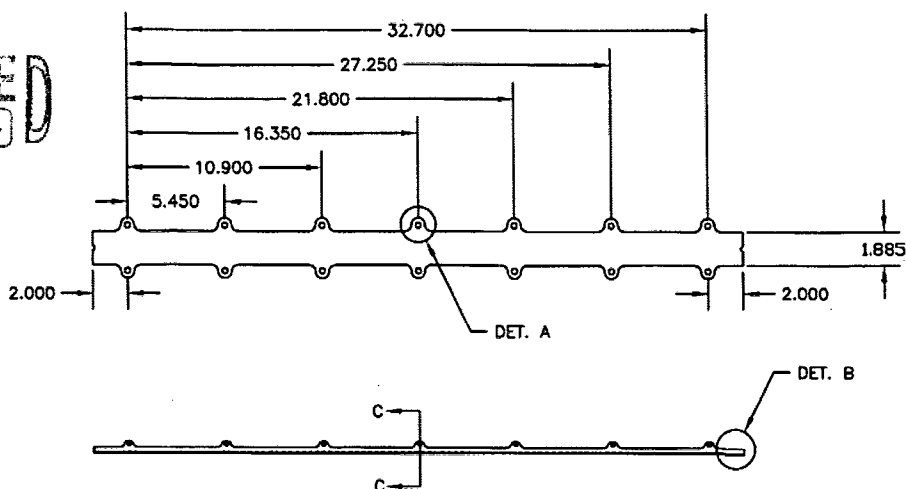
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NO. 43992



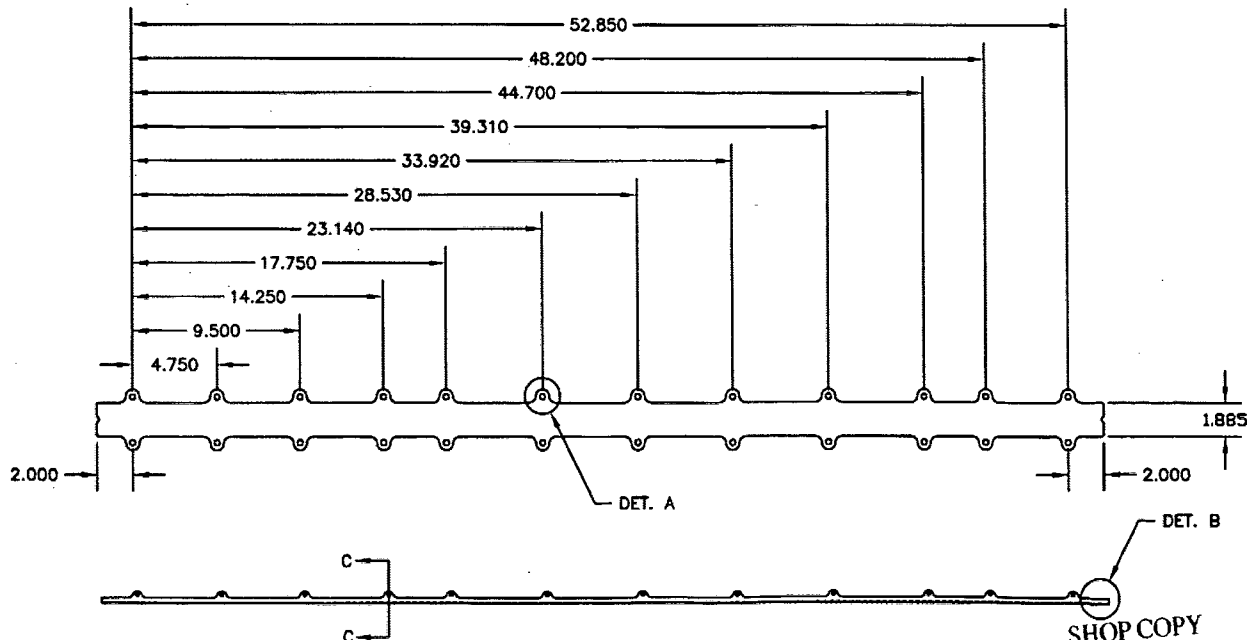
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.01.06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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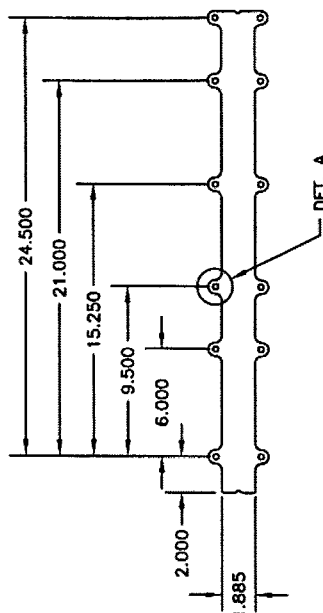
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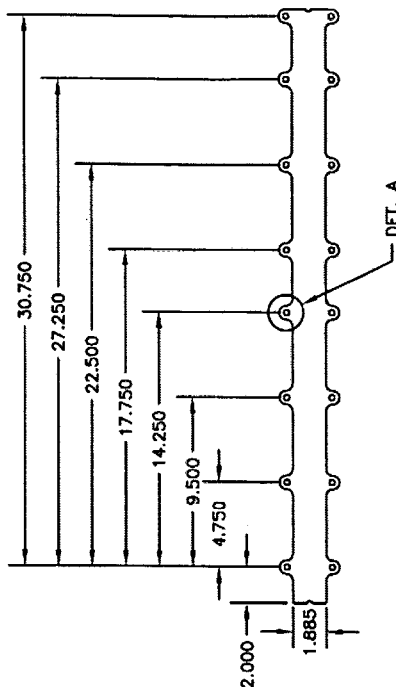


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

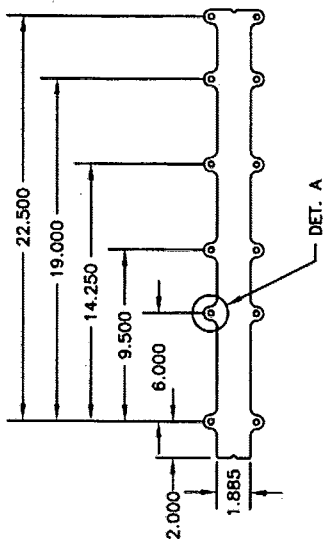


D2656-37

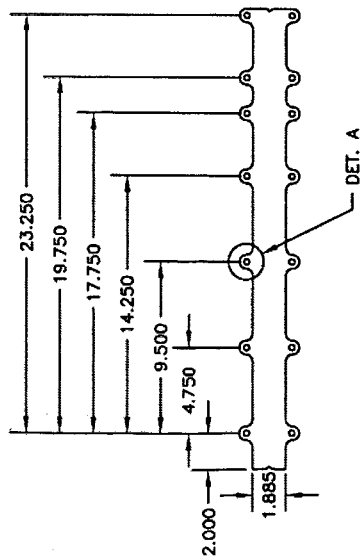


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D2656-31



D2656-35



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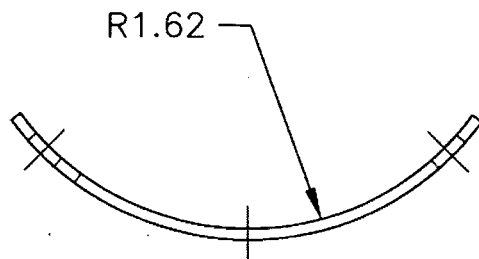
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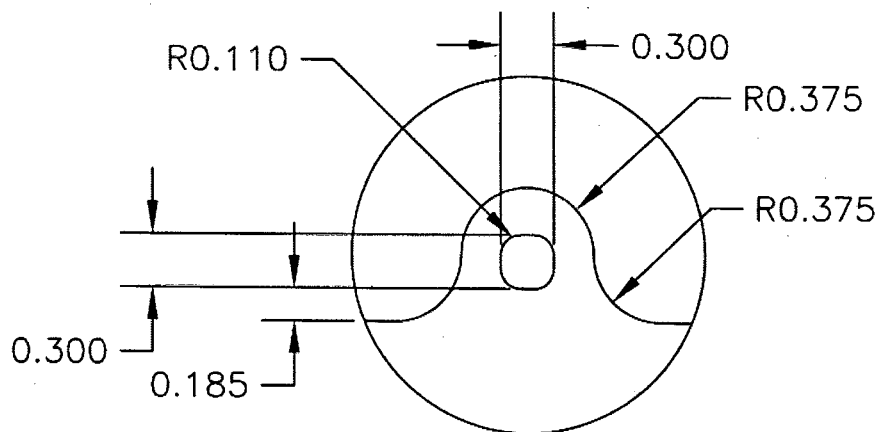
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

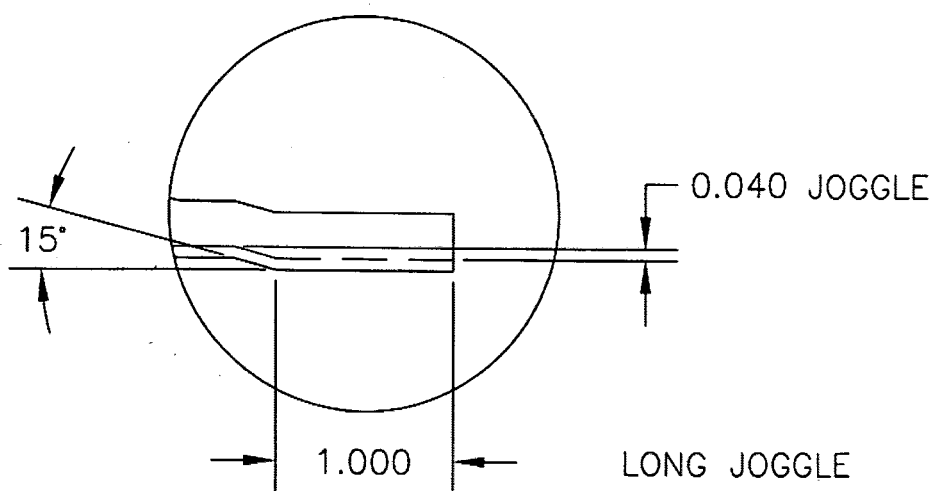


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05.09.06

DETAIL A



DETAIL B



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